

S/20

DART AEROSPACE LTD	Work Order:	23040
Description: Inside Washer	Part Number:	D3233-1
Dwg: D3233 Rev. B PAGE 2 REV. 06.14	Qty:	82 23
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	KJ	05.04.13	20
2	MC	Turn as per Folio FA517 and Dwg D3233 Material: AISI 1020-1025 Seamless Tubing 2" x 0.500" wall Identify for D3233-1	M 1015	JG	05/07/04 23
3	QC2	Inspect parts as they come off the machine Identify as D3233-1	JG	05/07/04	23
4	QC8	Second check	EC	05.07.04	23
5	MC	Deburr	JG	05/07/04	23
6	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	M	05.08.11	23
7	QC3	Inspect Powder Coat	Z	05.08.15	23
8	QC5	Inspect work to Step 5	Z	05.08.15	23
9	ST	Identify and Stock	CPL	05.08.15	23
10	AC	Cost / part: 3.5C	Svr	05.08.17	23
11	DC	Close W/O 3, 13 Inspect Level 21	(P)	05/08/17	23

Rev	Date	Change	Revised By	Approved
A	05.03.11	New issue	KJ/JLM	
B	05.03.31	Added Powder Coat	KJ/JLM	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
		- Update dug with change. (see attached dug for detail)					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA

Date: 05/08/17

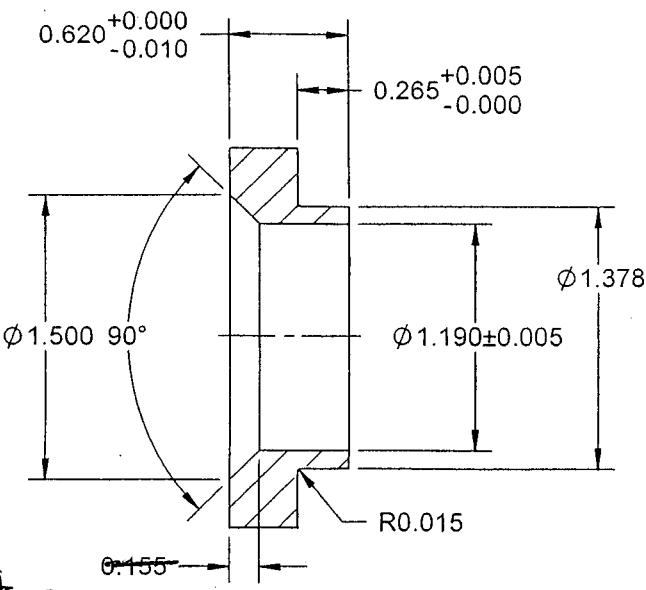
NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

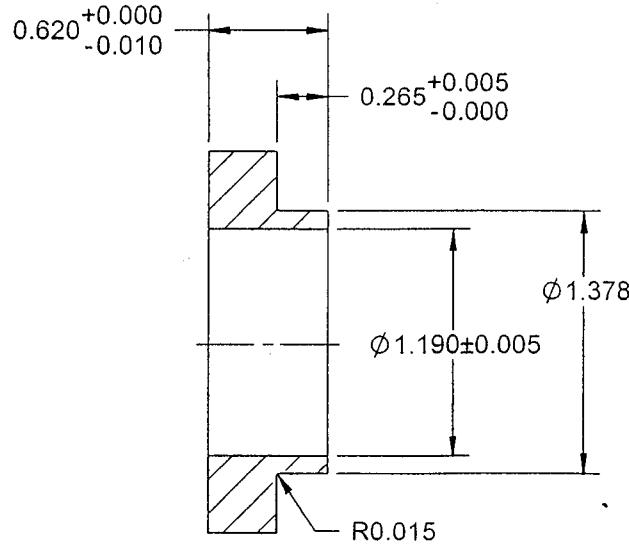
DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3233	REV. B SHEET 2 OF 3
DATE 05.03.08	TITLE WHEEL ASSEMBLY	SCALE 1:1	



[Signature] 05.07.04
SECTION A-A

D3233-1 INSIDE WASHER



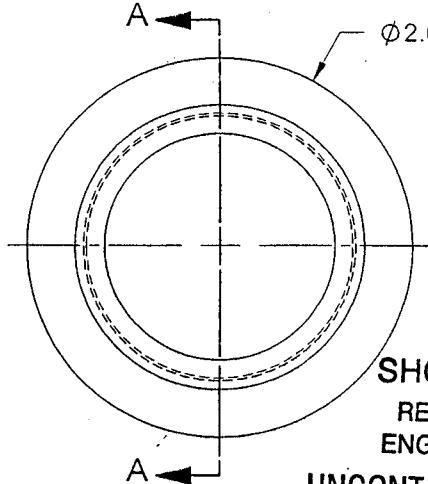
SECTION B-B

D3233-3 OUTSIDE WASHER

NOTES:

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00
MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS
(REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

RELEASED
[Signature]
05/05/04

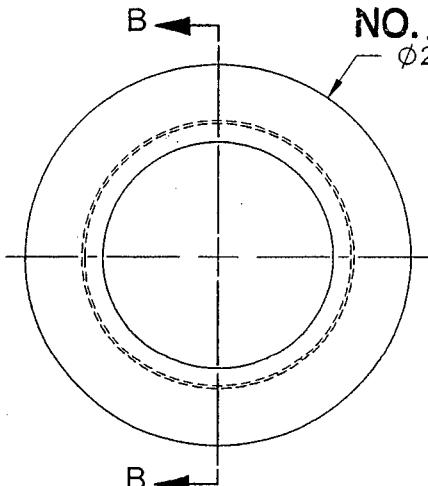


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WITHOUT NOTICE

WORK ORDER

NO. 23040
Ø2.00



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2005
02:25 pm

Work Order No	:	0023040	Department Code:	
Project Name	:	D3233-1	Burden Flags	: NNNNNNN
Project For	:	WK520	WO Status	: Open
Work Order Type	:	Main	Invoice State	: Not Invoiced
Main WO Number	:		Invoice Date	:
House Part Number	:	D3233-1	Invoice Number	:
Description	:	Inside Washer	Invoice Amount	: 0.00
Manufactured	:	Yes		
Amount Req'd	:	20	Order Entry No	:
Amount Done	:	0	OE Value	: 0.00
Start Date	:	04-12-05	Est Mark Up	: 0.000%
Est Finish Date	:	05-15-05	Actual Mark Up	: 0.000%
Act Finish Date	:			
Drawings Reqd	:	No		
Ok for Approval	:			
Approval Rec'd	:		\$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
<hr/>					
Burden	: 0.00	0.00	0.00		
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Total Cost	: 0.00	0.00	0.00		
Mark up	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/ (Loss)	: 0.00	0.00

DART AEROSPACE LTD	Work Order:	23040
Description:	Part Number:	D3233-1
Inspection Dwg: D3233 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by: S.G.	Audited by: G	Prototype Approval: N/A
Date: 05/07/04	Date: 05-07-04	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	